



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D205-626-013
Job Sheet 178725



Part No: D205-626-013

Job Qty: 2 ea

Part Name: Heli-Access-Handle™ LH Spacedoor™



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 6/6/18

Job Tracking No:

Due Date: 6/27/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C SHEET 8 IPP REV:A 17.01.17 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

JUN 14 2018

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	6/27/18	6/27/18	0.00	0.00	Start Up Stores/Pkg-1		JUN 21 2018
110	Packaging	2 pcs	6/27/18	6/27/18	0.00	0.00	Packaging1-2		JUN 22 2018
120	QC	2 pcs	6/27/18	6/27/18	0.00	0.00	QC4		JUN 25 2018
125	DC	2 pcs	6/27/18	6/27/18	0.00	0.00	DC		JUN 25 2018
130	Packaging	2 pcs	6/27/18	6/27/18	0.00	0.00	Packaging3-1		JUN 25 2018
140	QC21-FG	2 Ea	6/27/18	6/27/18	0.00	0.00	QC21		JUN 25 2018

Part Op 125 - Photocopy bluefile & type labels per PPP D205-626-013 CHG 001

Descriptions: 130 - Identify and pack for shipping as per PPP D205-626-013

F9029

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
80-005-1-8	Insert	4 Ea (2 ea)	90-Start up Operation	5083011
D2480-011	Handle Weldment LH	2 Ea (1 ea)	90-Start up Operation	5080925
D2481	Mounting Plate	4 Ea (2 ea)	90-Start up Operation	5083031
MS21042L08	Nut	8 Ea (4 ea)	90-Start up Operation	504234
MS27039-08-05	Screw	4 Ea (2 ea)	90-Start up Operation	F117316
MS27039-08-09	Screw	8 Ea (4 ea)	90-Start up Operation	F415833550
NAS1149FN816P	Washer	20 Ea (10 ea)	90-Start up Operation	F117316-25

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	80-005-1-8	4	0	0
	D2480-011	2	0	0
	D2481	4	7	0
	MS21042L08	8	1,605	0
	MS27039-08-05	4	70	0
	MS27039-08-09	8	194	0
	NAS1149FN816P	20	222	0

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Part Specifications

Specifications could not be found.



WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____
QA Closed: _____ Date: _____

Work Order update only

DISPOSITION		AGAINST DEPARTMENT/PROCESS			
Work Order: _____	Rework ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
Part No. _____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐
NCR No. _____	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Date: _____	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐	MRB (Q51042) Approval ☐
Step #: _____		QTY Effective: _____			
Description Work Order Deviation		Disposition			
Completed By _____					

Supervisor Verification

DART
AEROSPACE

Container No: S083098

Part: D205-626-013

Job No: 178725

Serial No/Batch: S083098

Revision: _____

Inspector: _____

Exp Date: _____

Instructions: _____

Coordinator

Dart Aerospace Corp.

1270 Aberdeen Street

Hewkesbury, ON K6A 1K7

CANADA

TEL: 1 613 632-5200

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Root Cause		FAULT CATEGORY												
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss	Folio/Progr	Grain	Weld	Wrong Stock	Out of Sequ	Off-set	Mislabeled	Fit/Function	Misread	Turning Sequence
Design	Operator	Bending	Set-up											
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route											
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect											
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified											
Material	Use for Testing	Cuffs	Contamination											
Internal Transport	Poor Information	Crushing	Countersink											
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short											
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear											
Substation	Process Improvement	Marks/Chatter	Drill Holes											
Past Expiry Date	Manufacturing Process													
Misidentified	Past Due													
OTHER: _____														



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
003989	S083095	80-005-1-8	Insert	s083011	ST584	4
003989	S082924	MS21042L08	Nut	s044234	ST303	8
003989	S082923	MS27039-08-05	Screw	f117316	ST278	4
003989	S082922	MS27039-08-09	Screw	fm138333-50	ST320	8
003989	S082921	NAS1149FN816P	Washer	f117316-25	ST263	20

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 6/21/18 3:28 PM dart.quirion.sonia

4. WEIGHT AND BALANCE

The following is the net weight increase associated with the D205-626 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-626-011 Heli-Access-Handle Kit™, LH	1.3 lb 0.59 kg	-46.5 in -1.18 m	-60.5 in-lb -0.70 m-kg	87.2 in 2.21 m	113.4 in-lb 1.31 m-kg
D205-626-012 Heli-Access-Handle Kit™, RH	1.3 lb 0.59 kg	46.5 in 1.18 m	60.5 in-lb 0.70 m-kg	87.2 in 2.21 m	113.4 in-lb 1.31 m-kg
D205-626-013 Heli-Access-Handle Kit™, LH (Spacedoor™)	1.3 lb 0.59 kg	-50.5 in -1.28 m	-65.7 in-lb -0.76 m-kg	87.2 in 2.21 m	113.4 in-lb 1.31 m-kg
D205-626-014 Heli-Access-Handle Kit™, RH (Spacedoor™)	1.3 lb 0.59 kg	50.5 in 1.28 m	65.7 in-lb 0.76 m-kg	87.2 in 2.21 m	113.4 in-lb 1.31 m-kg

5. PARTS LIST

Qty -011	Qty -012	Qty -013	Qty -014	Part Number	Description
X				D205-626-011	HELI-ACCESS-HANDLE™, LH (STANDARD)
	X			D205-626-012	HELI-ACCESS-HANDLE™, RH (STANDARD)
		X		D205-626-013	HELI-ACCESS-HANDLE™, LH (SPACEDOOR™)
			X	D205-626-014	HELI-ACCESS-HANDLE™, RH (SPACEDOOR™)
1		1		D2480-011	HANDLE ASSEMBLY, LH
	1		1	D2480-012	HANDLE ASSEMBLY, RH
		2	2	D2481	DOUBLER
		2	2	80-005-1-8	INSERT
6	6			AN526C632R7	SCREW
6	6			MS21042L06	NUT
		4	4	MS21042L08	NUT
		2	2	MS27039-0805	SCREW
		4	4	MS27039-0809	SCREW
6	6			NAS1149DN632J	WASHER (OR AN960JD6)
		10	10	NAS1149FN816P	WASHER (OR AN960-8L)